

Work Order ID 64025

Tuesday, November 23, 2010 8:05:53 AM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Assembly (350)

Stop



Start Date: 11/23/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *AS*Date: *10/11/23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4030

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*10/12/15**6/5/10/12/02 ①**⑦**8/10/12/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 64025


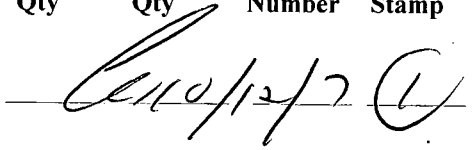

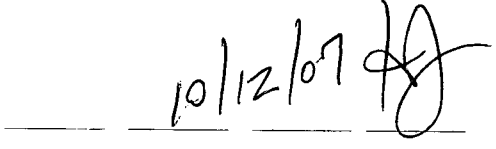
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Page 2

Item ID: D4030-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Long Basket Assembly (350)
Start Date: 11/23/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 11/30/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo PPP64022	0.00							
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

MF
10-12-07

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 64025

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)






Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	2.0000	1	1		10/12/11	sf
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				2					
				61224				2					
D2535  Spring		Manufactured	No			100	Each	52.0000	2	2		10/12/11	sf
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				52					
				58331				52					
D2537  Bushing		Manufactured	No			100	Each	34.0000	2	2		10/12/11	sf
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				34					
				59423				4					
				62393				30					
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1		10/12/11	sf
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1		10/12/11	sf

B64027 (12)

B64029 (12)

10/12/11

10/12/11

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Page 2

Work Order ID: 64025

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3917-3

Manufactured No

100 Each

21.0000

6



Washer



6
10/12/10 SP

Location

Loc Qty

Loc Code

ST095

20

63672

20

ST096

1

57144

1

6

D3953-3

Manufactured No

100 Each

3.0000

2



Gas Spring Stud, Lid



2
Sp 10/12/10

Location

Loc Qty

Loc Code

ST101

3

63673

3

D3953-7

Manufactured No

100 Each

4.0000

2



Spring Spacer



2
B64257 10/12/10 SP

Location

Loc Qty

Loc Code

ST101

3

63674

3

ST103

1

59438

1

D3953-9

Manufactured No

100 Each

4.0000

2



Gas Spring Washer



2
B64258 10/12/10 SP

Location

Loc Qty

Loc Code

ST101

2

63675

2

ST103

2

60008

2

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Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64025

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3953-17 Manufactured No 100 Each 3.0000 2 2
Gas Spring Spacer

Location Loc Qty Loc Code

ST101 3
57143 1
59197 2

D3953-19 Manufactured No 100 Each 8.0000 1 1
Gas Spring Bracket

Location Loc Qty Loc Code

ST 8
59213 8

D3953-21 Manufactured No 100 Each 16.0000 1 1
Gas Spring Bracket

Location Loc Qty Loc Code

ENG 5
56407 5
ST102 11
57145 2
59214 9

D3969-3 Manufactured No 100 Each 5.0000 1 1
Spring (Basket Lid)

Location Loc Qty Loc Code

ST 1
58986 1
ST272 4
63657 4

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Page 3

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64025

Parent Item: D4030-041









Parent Item Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN3-14A	Purchased	No	100	Each	92.0000	4	4	
							10/12/15	
Bolt								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST351	92				
			114941	42			4	
			115108	50				
AN3-16A	Purchased	No	100	Each	80.0000	2	2	
							10/12/15	
Bolt								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST352	80				
			114752	80			2	
AN5-17A	Purchased	No	100	Each	102.0000	4	4	
							10/12/15	
Bolt								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST339	102				
			114784	12			2	
			115594	40			2	
			116003	50				
AN4-12	Purchased	No	100	Each	25.0000	3	3	
							10/12/15	
Bolt								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST357	25				
			114292	2				
			114784	23			3	

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64025



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN310-4 Purchased No

100

Each

72.0000

3



NUT



3
10/12/10

Location

Loc Qty

Loc Code

ST324

72

115107

2

115936

20

116075

50

3

AN310C4 Purchased No

100

Each

30.0000

2



Nut



2
10/12/10

Location

Loc Qty

Loc Code

ST349

30

114306

30

2

MS21042L3 Purchased No

100

Each

1,627.000

6



Nut



6
10/12/10

Location

Loc Qty

Loc Code

ST300

1627

114784

631

115835

996

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64025

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,363.000

4

4



Nut



10/12/10

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1337

115156

137

115594

500

116104

200

116105

500

4

MS24665-151

Purchased

No

100

Each

600.0000

3

3



Cotter Pin



10/12/10

Location

Loc Qty

Loc Code

ST309

600

17566

600

3

MS24665-300

Purchased

No

100

Each

44.0000

2

2



Cotter Pin



10/12/10

Location

Loc Qty

Loc Code

ST309

44

105279

2

110123

42

2

Tuesday, November 23, 2010 8:05:58 AM

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Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 23, 2010 8:05:58 AM

Page 7

Work Order ID: 64025

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (J50)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P Purchased

No

100

Each

250.0000

6



Washer

Location

Loc Qty

Loc Code

ST275

250

112940

92

114405

1

114576

10

114718

2

116169

145

NAS1149F0563P Purchased

No

100

Each

180.0000

4



Washer

Location

Loc Qty

Loc Code

ST275

2

108471

2

ST298

178

114576

178

NAS1149F0332P Purchased

No

100

Each

463.0000

8



WASHER

Location

Loc Qty

Loc Code

ST275

463

18057

463

NAS1149C0432R Purchased

No

100

Each

378.0000

2



Washer

Location

Loc Qty

Loc Code

ST297

378

114292

50

114742

328

Tuesday, November 23, 2010 8:05:58 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

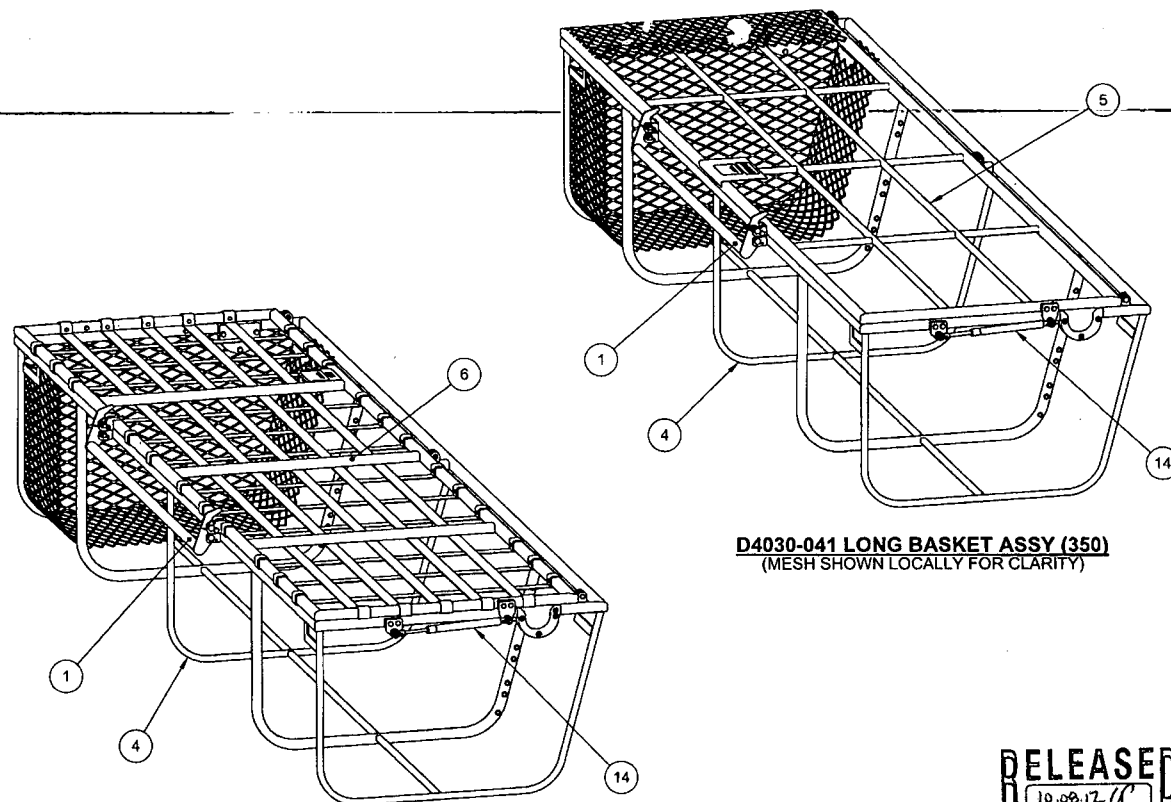
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLF VELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	4	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: -041: 72 lbs APPROX
 -043: 57 lbs APPROX

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 64125

PLC 11-25

RELEASED
 10.08.12
 ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JES	D4030	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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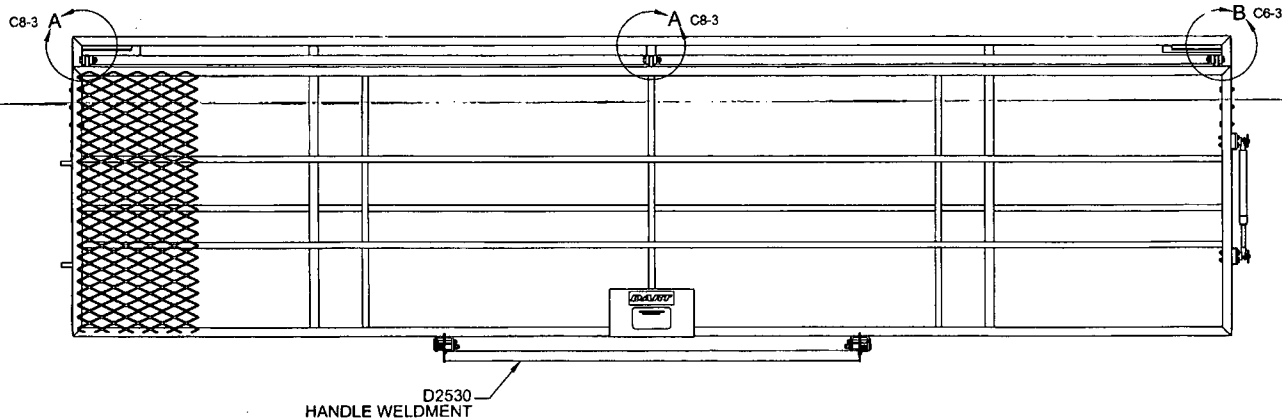
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

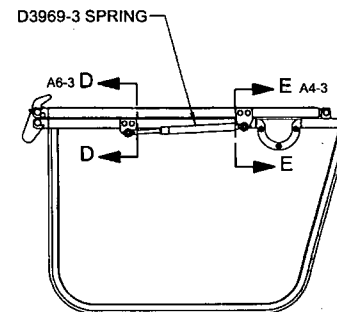
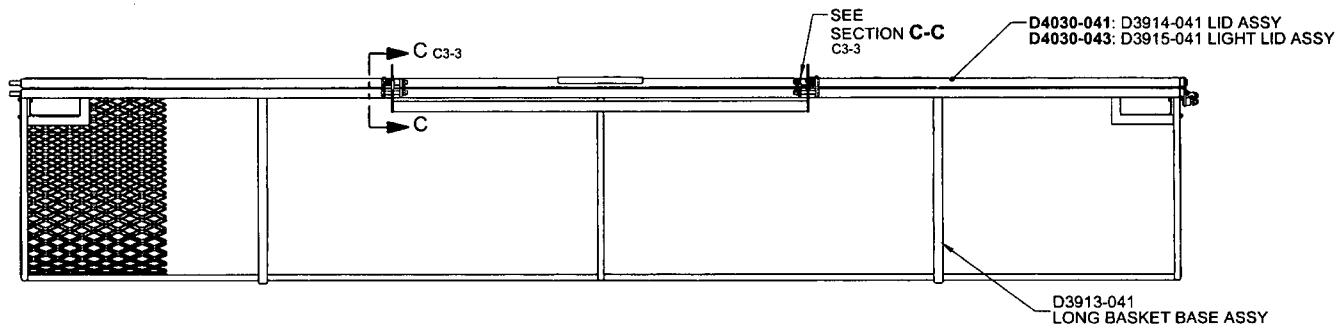
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



u604029



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	77	DRAWING NO.	REV. C
MFG. APPR.	SES	D4030	SHEET 2 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

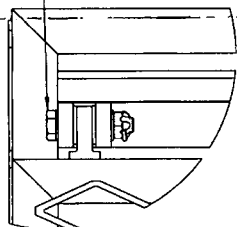
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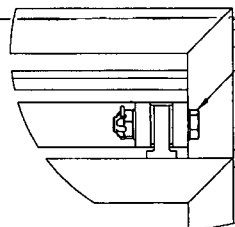
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



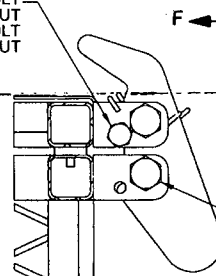
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

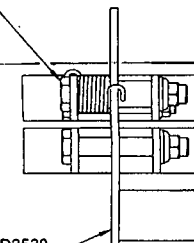


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350) - NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries